

Work Order ID 154936

Tuesday, January 03, 2017 4:03:34 PM

154936

Page 1

Item ID: D4273-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-640 Stop ***NS2***
Item Name: Basket Base Assembly, RH
Start Date: 1/30/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/6/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: JAN 03 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4273	E URF 17/1/4
D4279	B

100 Weld per dwg A/R S.S. rod Batch: 4136685 0.00
Large Fab

100

Large Fab

Large Fab

Memo 0.53

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION
N-N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS
INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on
basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear
fasteners holes on the ends (D4279-5/-9)

3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

DAS
43
9-89

APR 08 2017


PTO

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : 17/1/4	Step #: 100	QTY Effective : _____		MRB (QSI042) Approval DAS 12 9-89 17/1/4																	
Description Work Order Deviation		Disposition		Completed By																	
Install gty(3) D4017-7 Ribs, to prevent warping		Acceptable.																			
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Cust Item ID:
Customer:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>M 136657.</i>					<i>1</i>	<i>0</i>	<i>1704-11</i>	<i>23 33</i>
Powdercoat	Memo	0.09							
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT: <i>9:35</i>								
	START TIME: <i>9:35</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>10:05</i>								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

In d of M isloade **DAS 15 9-89**

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
3030								Lead hand / Supervisor Approval Verification	
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150	Identify as per dwg & Stock Location: <u>W10</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

17/4/13 AG
DAS
21
9-89
APR 12 2017
POSITIVE RECALL
EFFECTIVE 17-1-3 AUTH AA
RELEASED DD DATE 17-04-12

DQA: _____ Date: _____



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Picklist Print

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Page 1

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Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 1/30/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC IPP Rev:B
11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03
AS PER DWG REV.D DD verf:EC IPP REV:D 12.07.24 AS PER
DWG REV.E DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4672-1		Manufactured	No			100	Each	33.0000	2	2		DAS 43 9-89	
✓ *D4672-1*													
Blanking Plate													

****B153098 → 2x** APR 04 2017

Location	Loc Qty	Loc Code
WA004	33	
147331	3	
153098	16	
153476	10	
154520	4	

M304EX0.75-16F Purchased No

100 sf 1,069.200 32 32

✓ ***M304FX0 75-16F***

Expanded Metal Flat SS

****4136991 → 32x6** DAS 43 9-89 APR 04 2017

Location	Loc Qty	Loc Code
WA004	1069.19996	
M136012	429.19996	
M136467	640	

D3913-1 Manufactured No

100 Each 9.0000 1 1

✓ ***D3913-1***

Rib

****B157756 → 1x** DAS 43 9-89 APR 04 2017

Location	Loc Qty	Loc Code
WA004	9	
146459	8	
150369	1	

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, January 03, 2017 4:03:39 PM

Page 2

Work Order ID: 154936

154936

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 1/30/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each

6.0000

1 1

DAS

43

9-89

APR 04 2017

✓ *D3913-3*

Rib

**B157564 → 1x

Location

Loc Qty

Loc Code

WA004

6

144939

1

154287

5

D3913-9 Manufactured No

100 Each

6.0000

1 1

DAS

43

9-89

APR 04 2017

✓ *D3913-9*

Hinge Rib

**B155678 → 1x

Location

Loc Qty

Loc Code

WA004

6

150159

1

154288

5

D3916-5 Manufactured No

100 Each

8.0000

3 3

DAS

43

9-89

APR 04 2017

✓ *D3916-5*

Light Rib

**B157751 → 3x

Location

Loc Qty

Loc Code

WA004

8

146442

8

D4017-7 Manufactured No

100 Each

18.0000

13 1

DAS

43

9-89

APR 04 2017

✓ *D4017-7*

Rib

**B152997 → 1x

B158198 → 2x

Location

Loc Qty

Loc Code

WA004

18

150300

18

Qty(3) 01/17/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

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Page 3

Work Order ID: 154936

154936

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 1/30/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4277-3 Manufactured No

100 Each

2.0000

1 1

DAS

✓ *D4277-3*

Rib

** B157503 → 1x

43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

2

144853

2

D4277-5 Manufactured No

100 Each

4.0000

2 2

DAS

✓ *D4277-5*

Rib

** B157531 → 2x

43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

4

144854

4

D4277-9 Manufactured No

100 Each

0.0000

1 1

DAS

✓ *D4277-9*

Rib

B146419 → x

** B151129 → 1x

43
9-89

APR 04 2017

D4277-19 Manufactured No

100 Each

2.0000

1 1

DAS

✓ *D4277-19*

Rib

** B151129 → 1x

43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

2

144855

2

D4278-041 Manufactured No

100 Each

3.0000

1 1

DAS

* D4278-041*

Upper Rib Assembly-Hoop

** B157466 → 1x

43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

3

144857

3

Tuesday, January 03, 2017 4:03:40 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Tuesday, January 03, 2017 4:03:40 PM

Page 4

Work Order ID: 154936

154936

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 1/30/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4278-045 Manufactured No

100 Each

4.0000

2 2

✓ *D4278-045*

Rib Assembly, Fwd Cham

**B 157557 → 2x

DAS
43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

4

143991

2

144859

2

D4278-047 Manufactured No

100 Each

2.0000

1 1

✓ *D4278-047*

Upper Rib Assembly-Straight

**B 151034 → 1x

DAS
43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

2

144858

2

D4306-1 Manufactured No

100 Each

8.0000

1 1

✓ *D4306-1*

Rib

**B 146425 → 1x

DAS
43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

8

146250

2

146425

6

D4306-044 Manufactured No

100 Each

3.0000

1 1

✱ *D4306-044*

Rib Assembly, RH

**B 157460 → 1x

DAS
43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

3

144860

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : _____																									

Picklist Print

Tuesday, January 03, 2017 4:03:40 PM

Page 5

Work Order ID: 154936

154936

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 1/30/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4306-045 Manufactured No

100 Each 2.0000 1 1

✓ ***D4306-045***

Rib Assembly

****B144861 → 1x** DAS 43 APR 04 201
9-89

Location Loc Qty Loc Code

WA004

2

144861

2

D2581 Manufactured No

100 Each 66.0000 2 2

✓ ***D2581***

Mounting Bracket

****B157620 → 2x** DAS 43 APR 04 201
9-89

Location Loc Qty Loc Code

WA004

66

132771

1

136270

2

139082

2

146089

1

147603

2

148944

26

151990

4

154019

12

154549

16

D3913-15 Manufactured No

100 Each 11.0000 1 1

✓ ***D3913-15***

Wide Handle Plate

****B153005 → 1x** DAS 43 APR 04 201
9-89

Location Loc Qty Loc Code

WA004

11

148683

3

153004

2

153005

2

153500

4

Tuesday, January 03, 2017 4:03:40 PM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																						

Date: _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor Approval Verification
				QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Tuesday, January 03, 2017 4:03:40 PM

Work Order ID: 154936

154936

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 1/30/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4016-1 Manufactured No

100 Each

62.0000

3 3

✓ ***D4016-1***

Hinge Half, Base

****B 155346 → 3***

DAS
43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

62

144593

12

152180

28

154145

22

D4021-1 Manufactured No

100 Each

39.0000

3 3

✓ ***D4021-1***

Handle Plate

****B 155731 → 3***

DAS
43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

39

139529

1

147389

3

149655

3

151073

13

152239

6

152973

9

153487

1

154212

3

D4279-5 Manufactured No

100 Each

5.0000

1 1

✓ ***D4279-5***

End Mesh, Basket

****B 157486 → 1***

DAS
43
9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA006

5

142685

4

153978

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval _____																		
Description Work Order Deviation				Disposition																					
								Completed By _____																	
								Lead hand / Supervisor Approval Verification _____																	
								QC / QA Coordinator Approval _____																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Picklist Print

Tuesday, January 03, 2017 4:03:40 PM

Page 7

Work Order ID: 154936

154936

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 1/30/2017

Required Date: 2/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4279-7

Manufactured No

100

Each

10.0000

2

2

DAS

✓ ***D4279-7***

End Mesh, Basket

**B153983 → 2x 43 9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA006

10

142697

4

146388

2

153983

4

D4279-9

Manufactured No

100

Each

5.0000

1

1

DAS

✓ ***D4279-9***

End Mesh, Basket

**B151140 → 1x 43 9-89

APR 04 2017

Location

Loc Qty

Loc Code

WA004

2

127741

1

✓ 131154

1

WA006

3

151140

2

154020

1

DQA: _____ Date: _____



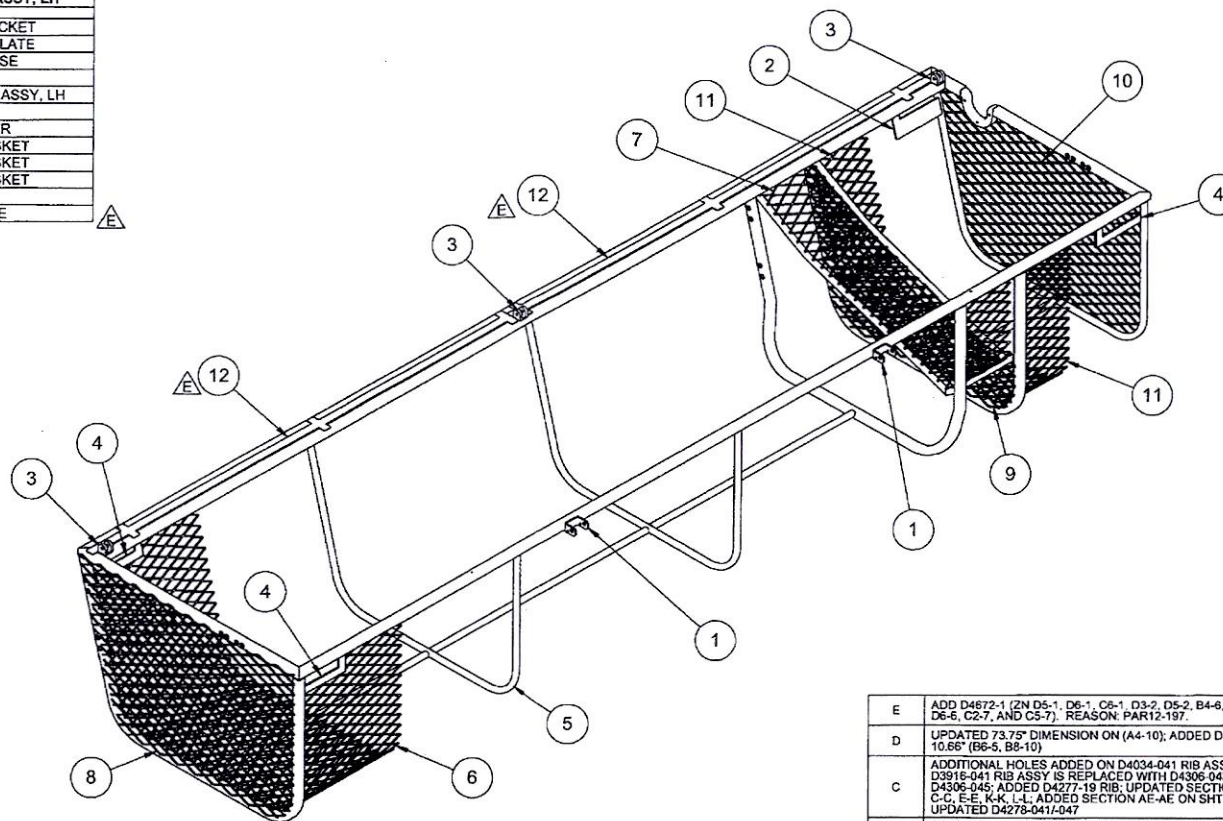
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Description Work Order Deviation				Disposition				Completed By																																																									
1005 11 0 592								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4273-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-141	BASKET FRAME ASSY, LH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE
12	2	D4672-1	BLANKING PLATE



D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

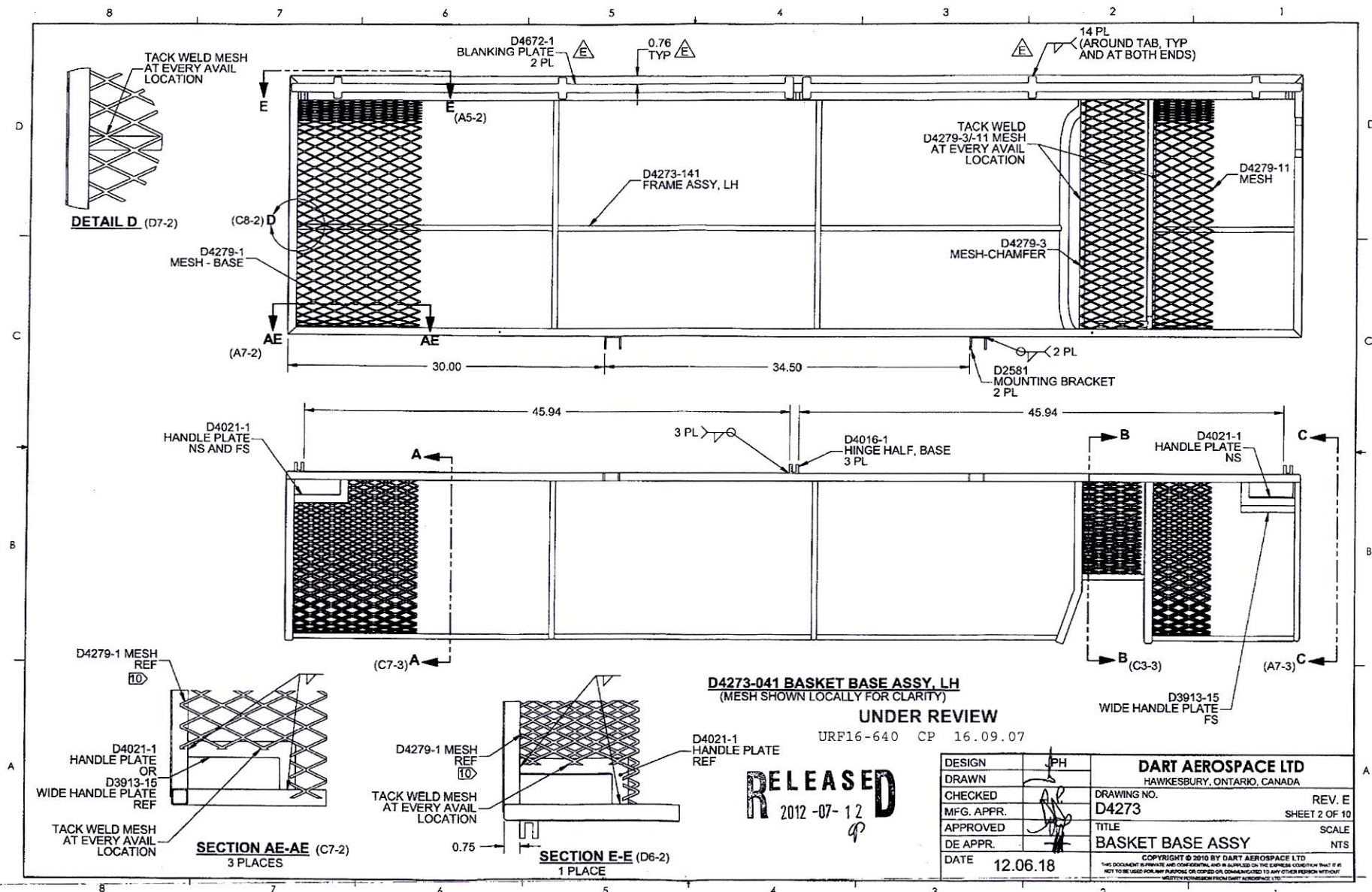
UNDER REVIEW

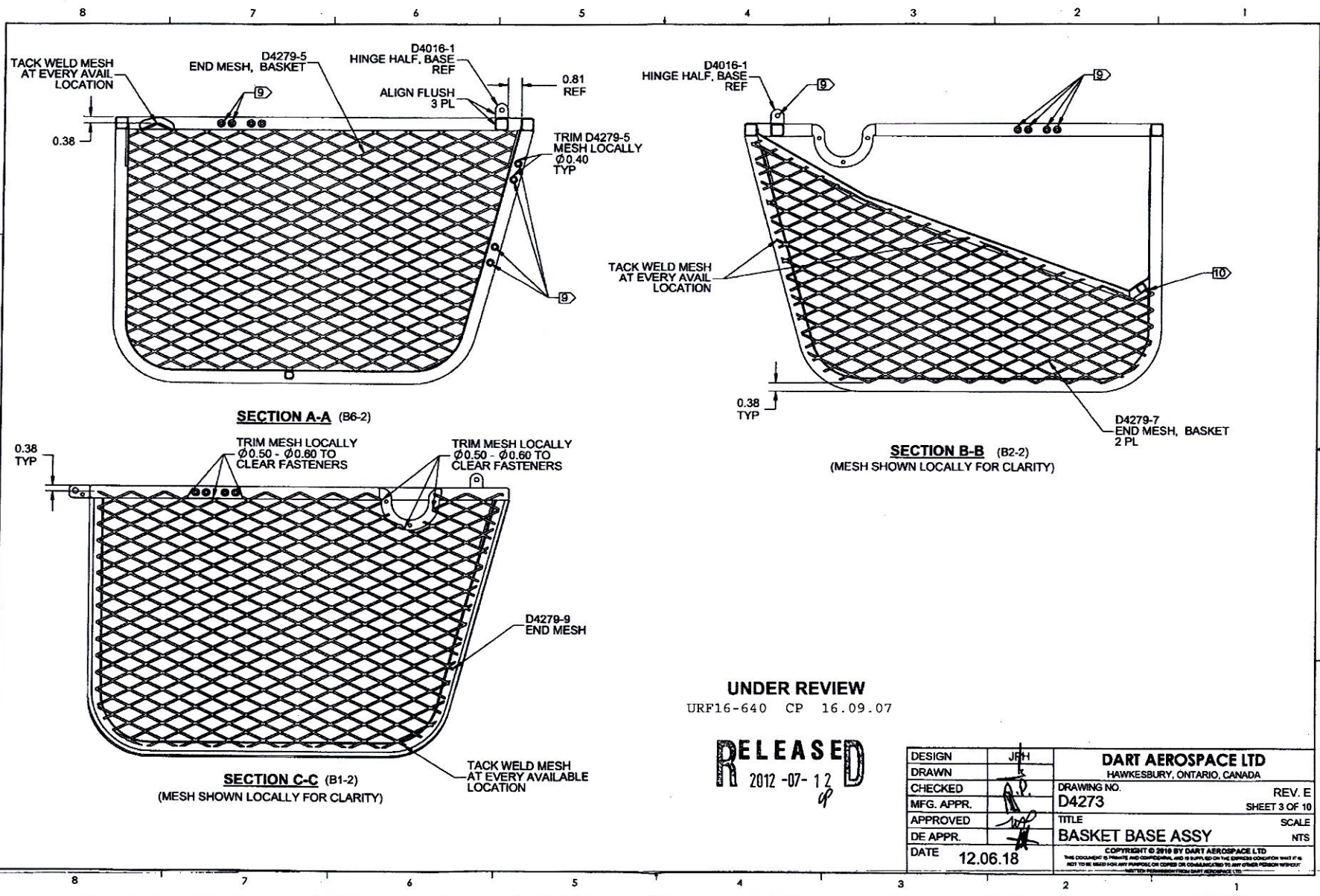
URF16-640 CP 16.09.07

RELEASED
2012-07-12
CP EN 12-61

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **154936**
JAN 03 2017

E	ADD D4672-1 (2N D5-1, D6-1, C5-1, D3-2, D5-2, B4-6, C3-6, D6-6, C2-7, AND C5-7). REASON: PAR12-197.	NB	12.06.18
D	UPDATED 73.75" DIMENSION ON (A4-10); ADDED DIM 10.66" (B6-5, B8-10)	SC	11.02.09
C	ADDITIONAL HOLES ADDED ON D4034-041 RIB ASSY: D3916-041 RIB ASSY IS REPLACED WITH D4306-043-044 & D4306-045; ADDED D4277-19 RIB; UPDATED SECTION B-B, C-C, E-E, K-K, L-L; ADDED SECTION AE-AE ON SHT 2; UPDATED D4278-041-047	SC	10.12.23
B	REDESIGN: ADD (1) D4021-1, (1) D4279-7, (1) D4279-11 (D6-1, D6-8); RMV D4277-17, D4278-043 (SHT 4, 9); ADD (1) D3916-1, (2) D4277-5, (1) D4277-9, (1) D4306-1 (D6-4, D6-9), RMV (1) D4277-3 (D6-4, D6-9); 24.25 WAS 20.25 (A5-5, A5-10)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4273 BASKET BASE ASSY SHEET 1 OF 10 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.18		



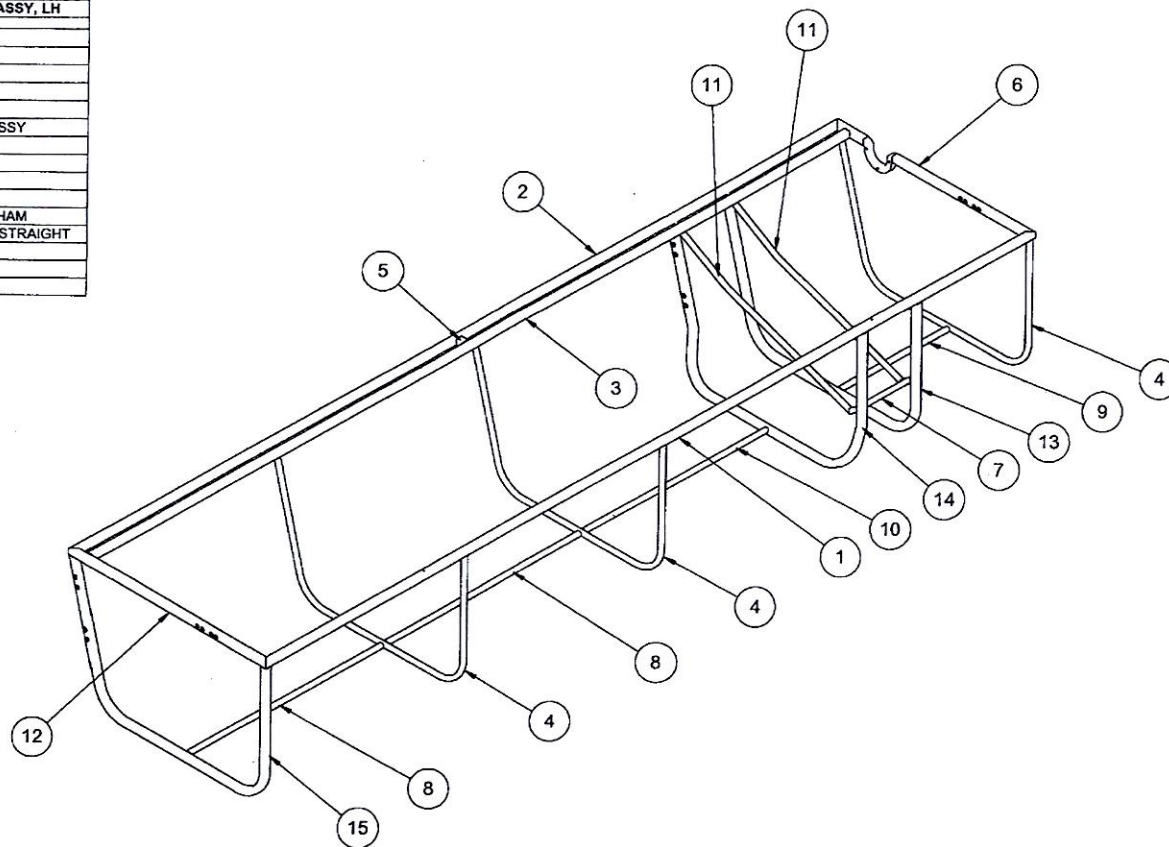


UNDER REVIEW
URF16-640 CP 16.09.07

RELEASED
2012-07-12

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D4273	SHEET 3 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSY	NTS
DATE	12.06.18	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-141	BASKET FRAME ASSY, LH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4034-041	AFT UPPER RIB ASSY
7	1	D4277-3	RIB
8	2	D4277-5	RIB
9	1	D4277-9	RIB
10	1	D4277-19	RIB
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-043	RIB ASSY, LH
15	1	D4306-045	RIB ASSY

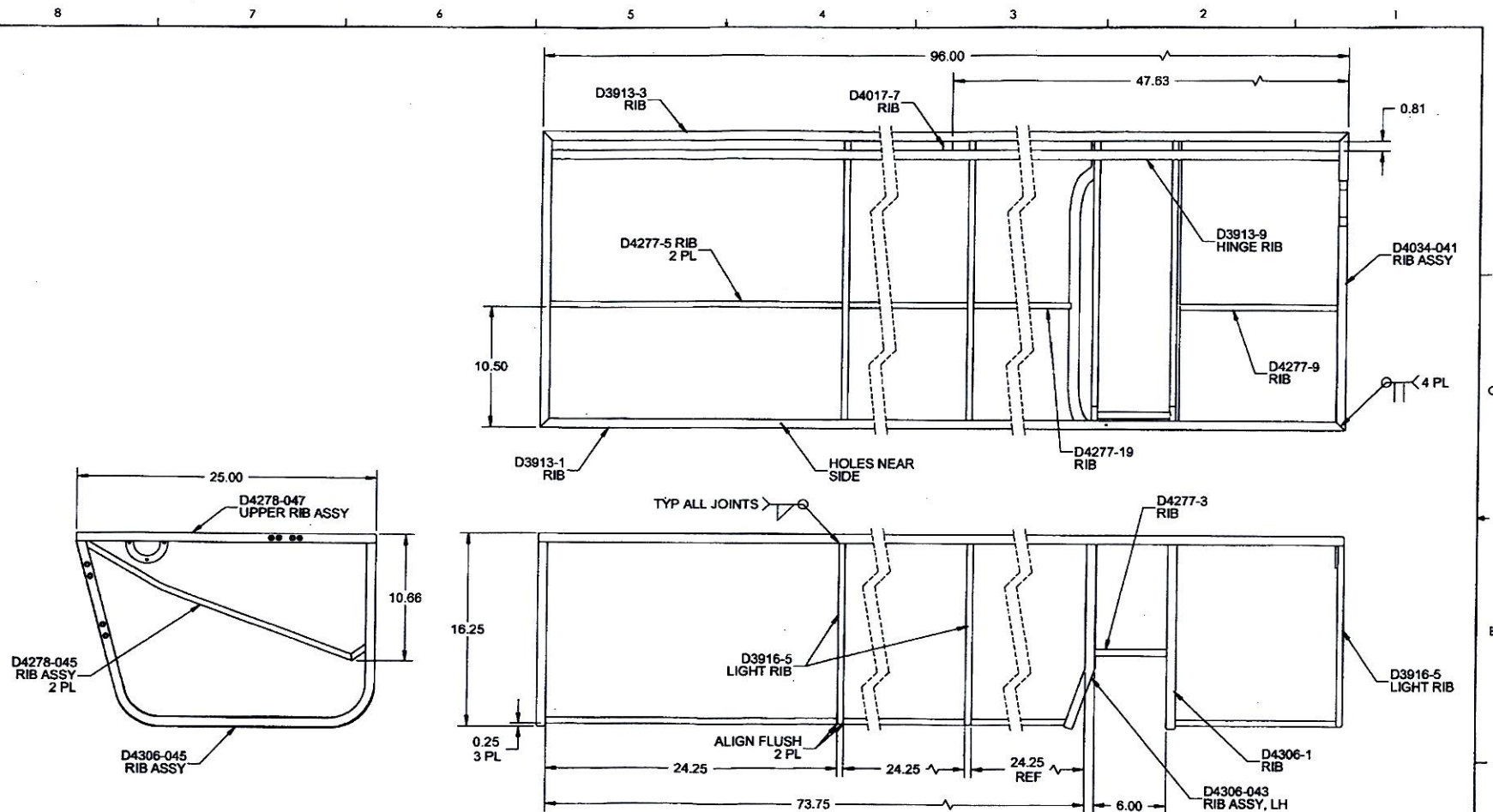


D4273-141 BASKET FRAME ASSY, LH

UNDER REVIEW
URF16-640 CP 16.09.07

RELEASED
2012-07-12
up

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. E
CHECKED		D4273	SHEET 4 OF 10
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSY	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DART AEROSPACE LTD'S PERMISSION	
DATE	12.06.18		



D4273-141 BASKET FRAME ASSY, LH

UNDER REVIEW

URF16-640 CP 16.09.07

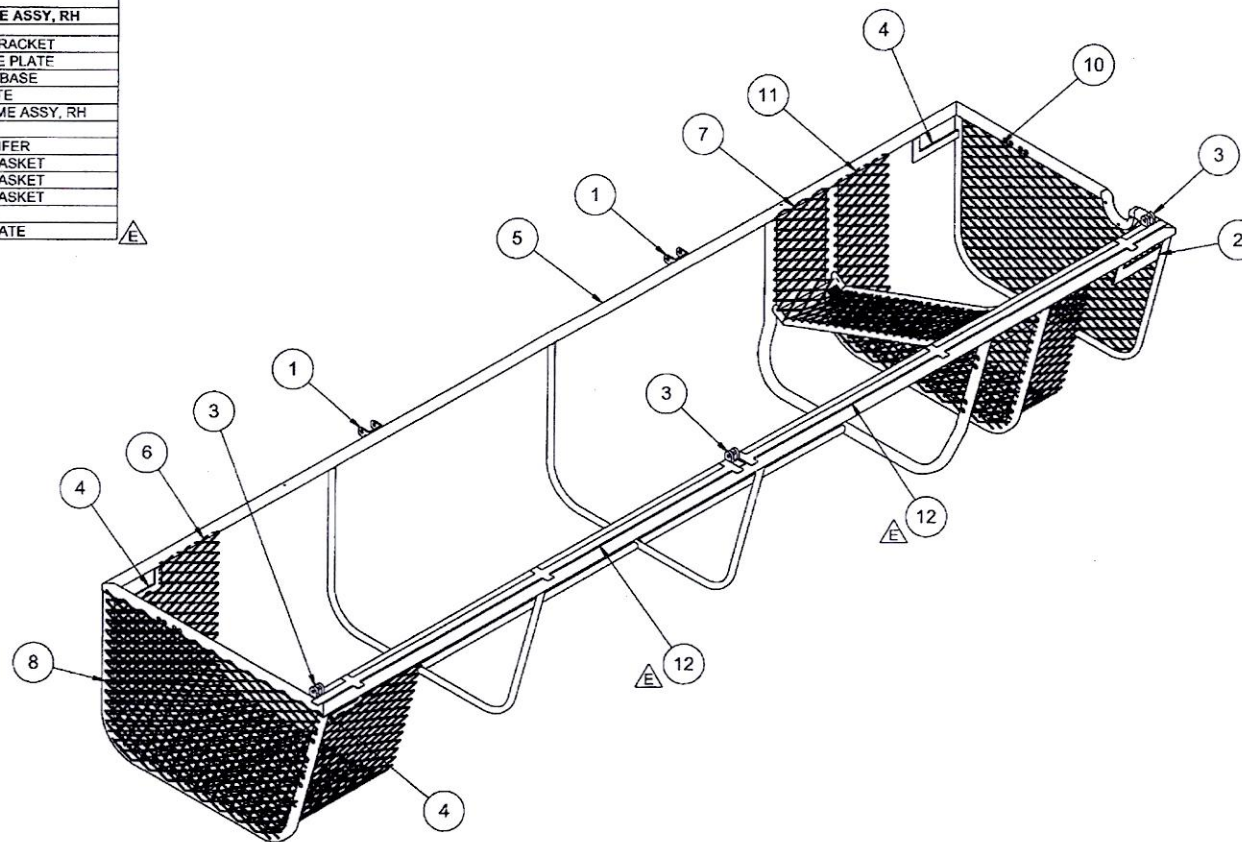
RELEASED
2012-07-12
UP

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D4273	REV. E
CHECKED			SHEET 5 OF 10
MFG. APPR.		TITLE BASKET BASE ASSY	SCALE NTS
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DE APPR.		DATE 12.06.18	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 24.75 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY	P/N	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE
12	2	D4672-1	BLANKING PLATE



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

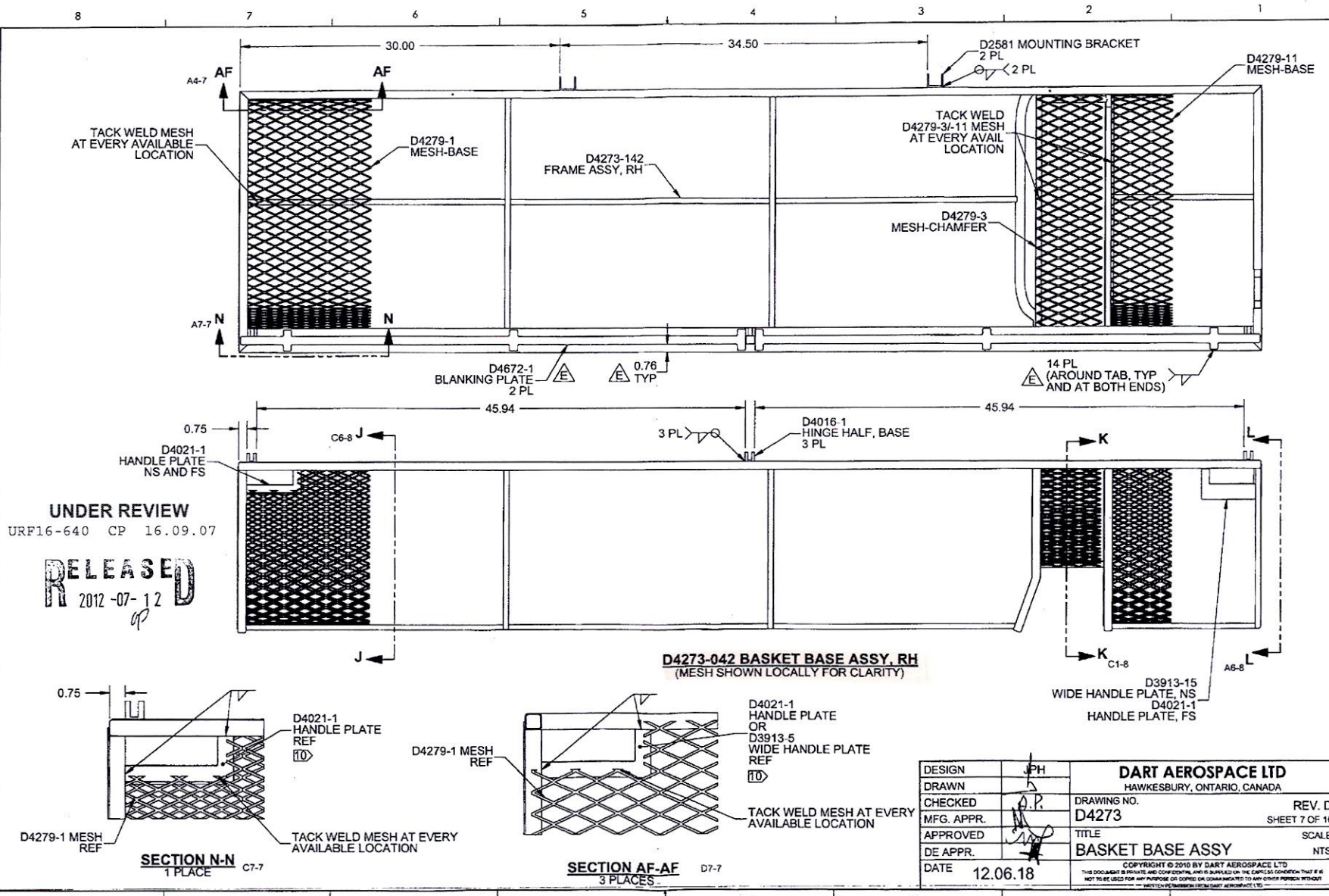
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

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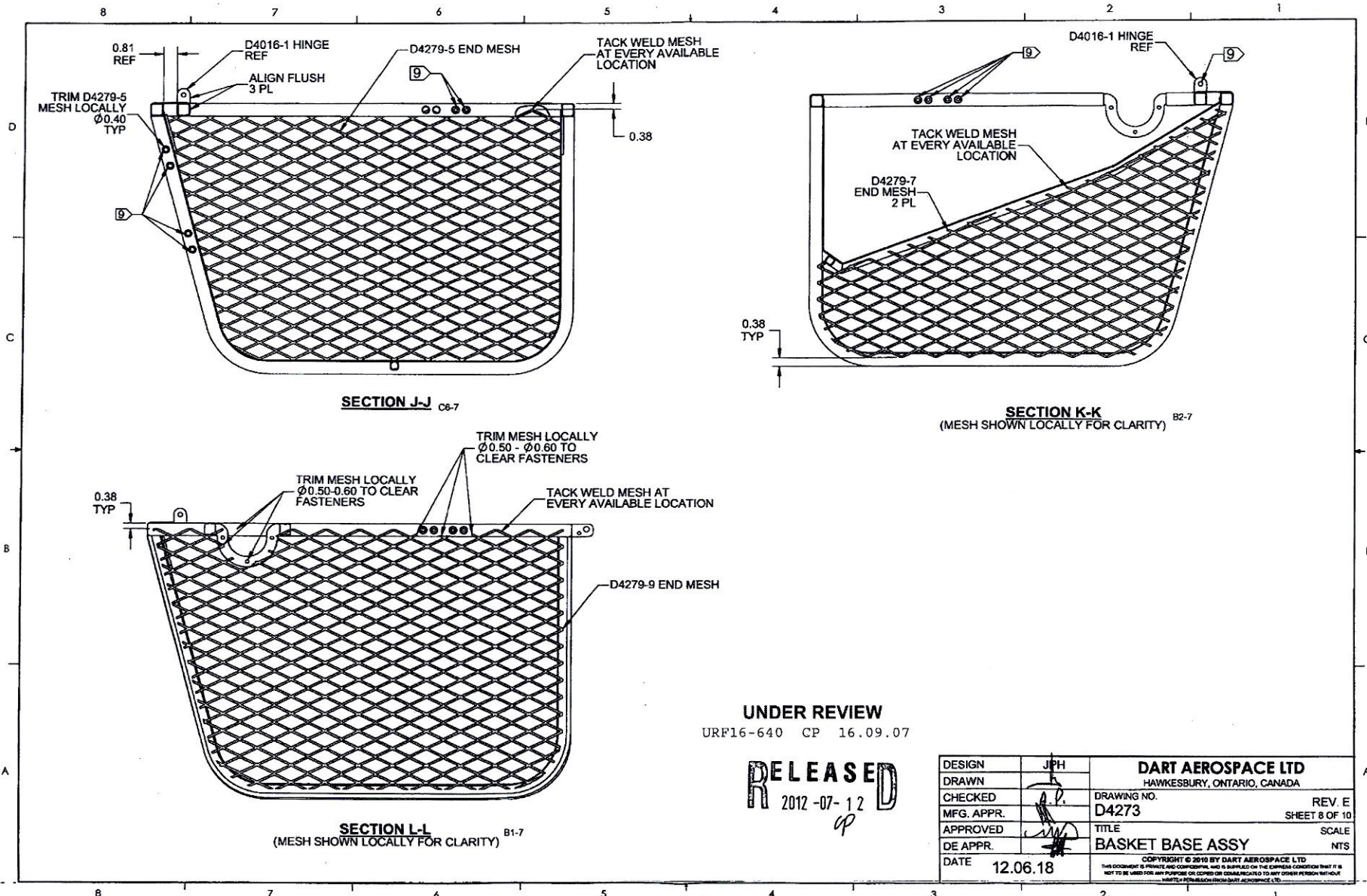
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DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. D4273	REV. E
MFG. APPR.			SHEET 6 OF 10
APPROVED		TITLE BASKET BASE ASSY	SCALE
DE APPR.			NTS
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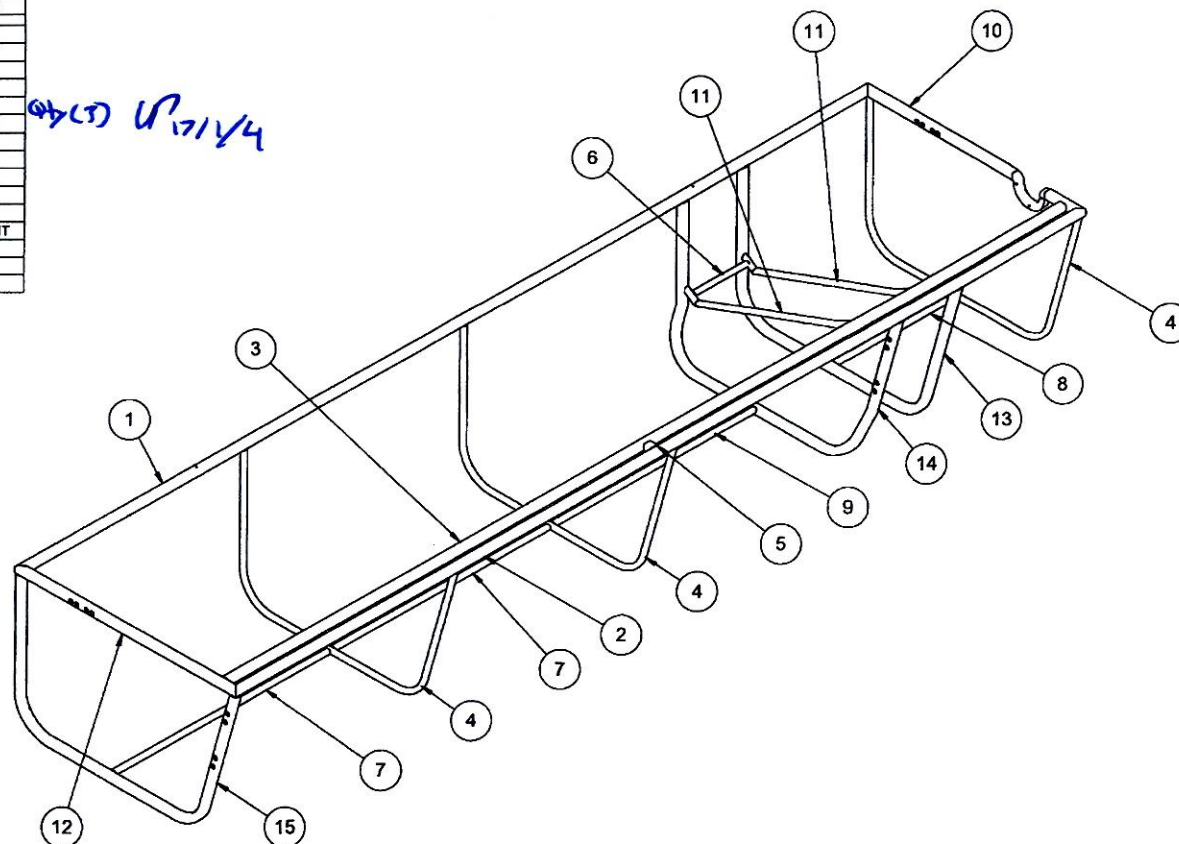


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DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A.P.	DRAWING NO. D4273	REV. E
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MFG. APPR.		TITLE BASKET BASE ASSY	SCALE NTS
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DE APPR.		DATE 12.06.18	

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	3	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY

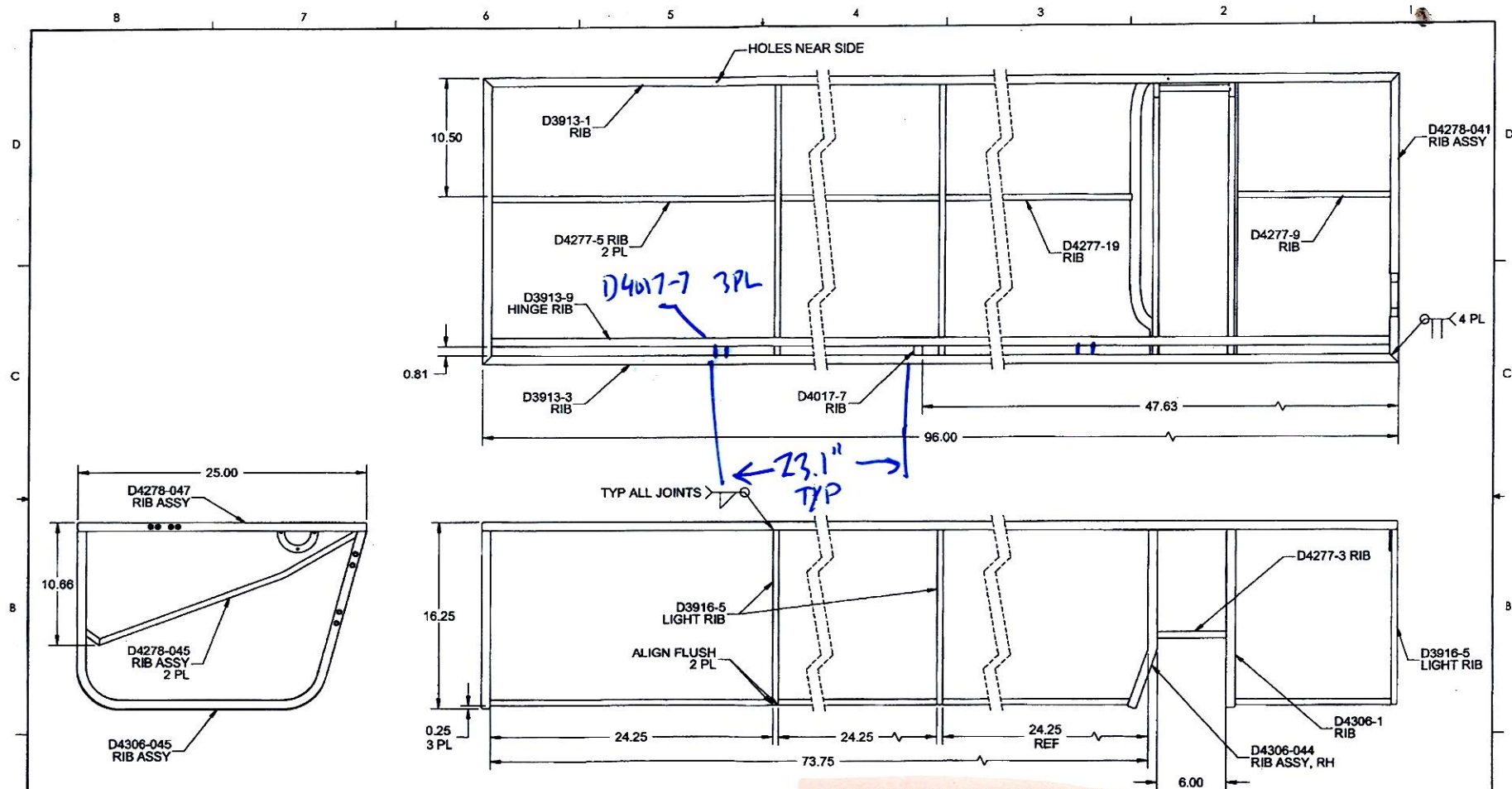


D4273-142 BASKET FRAME ASSY, RH

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.R.	DRAWING NO.	REV. E
MFG. APPR.		D4273	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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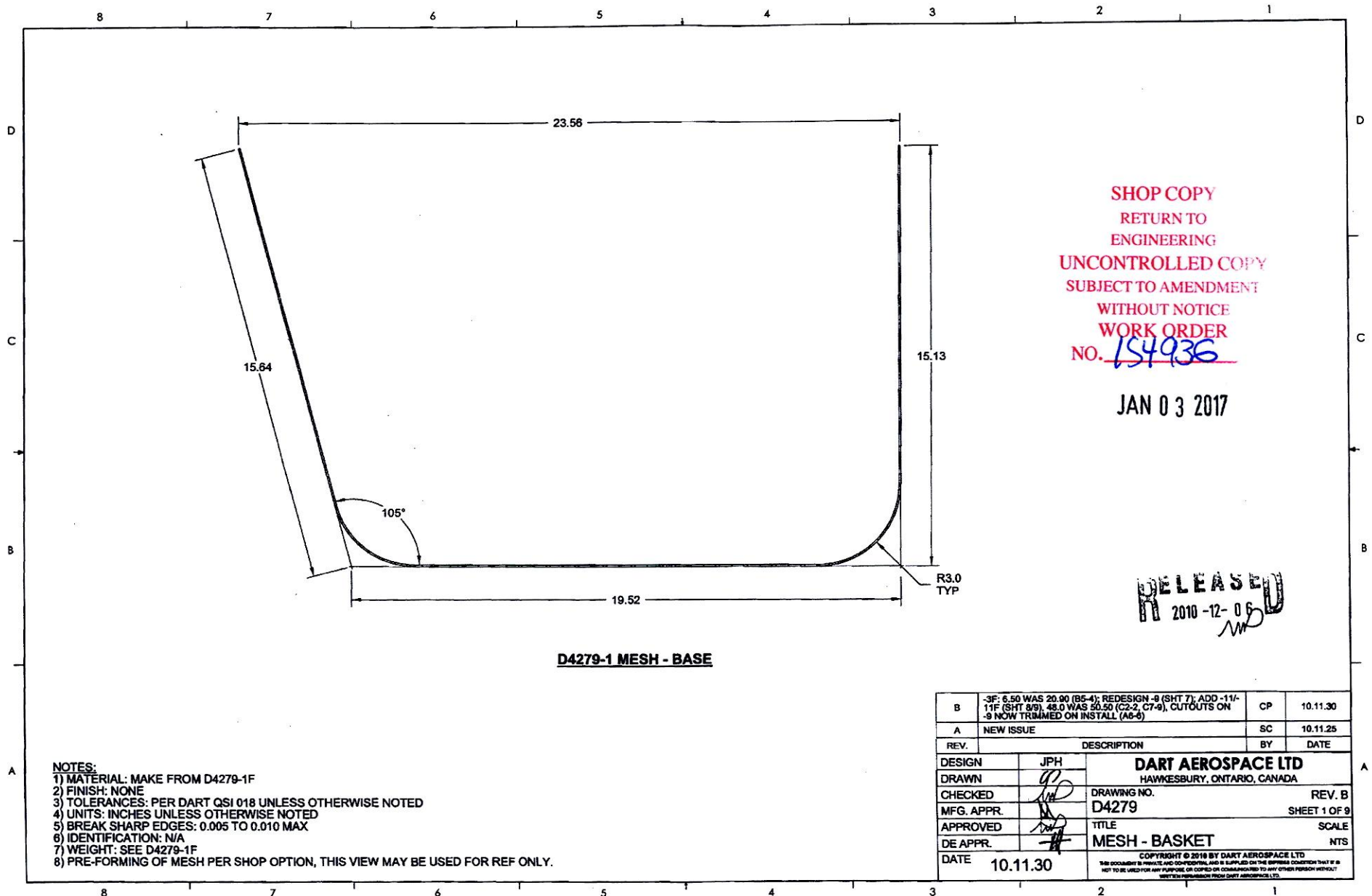


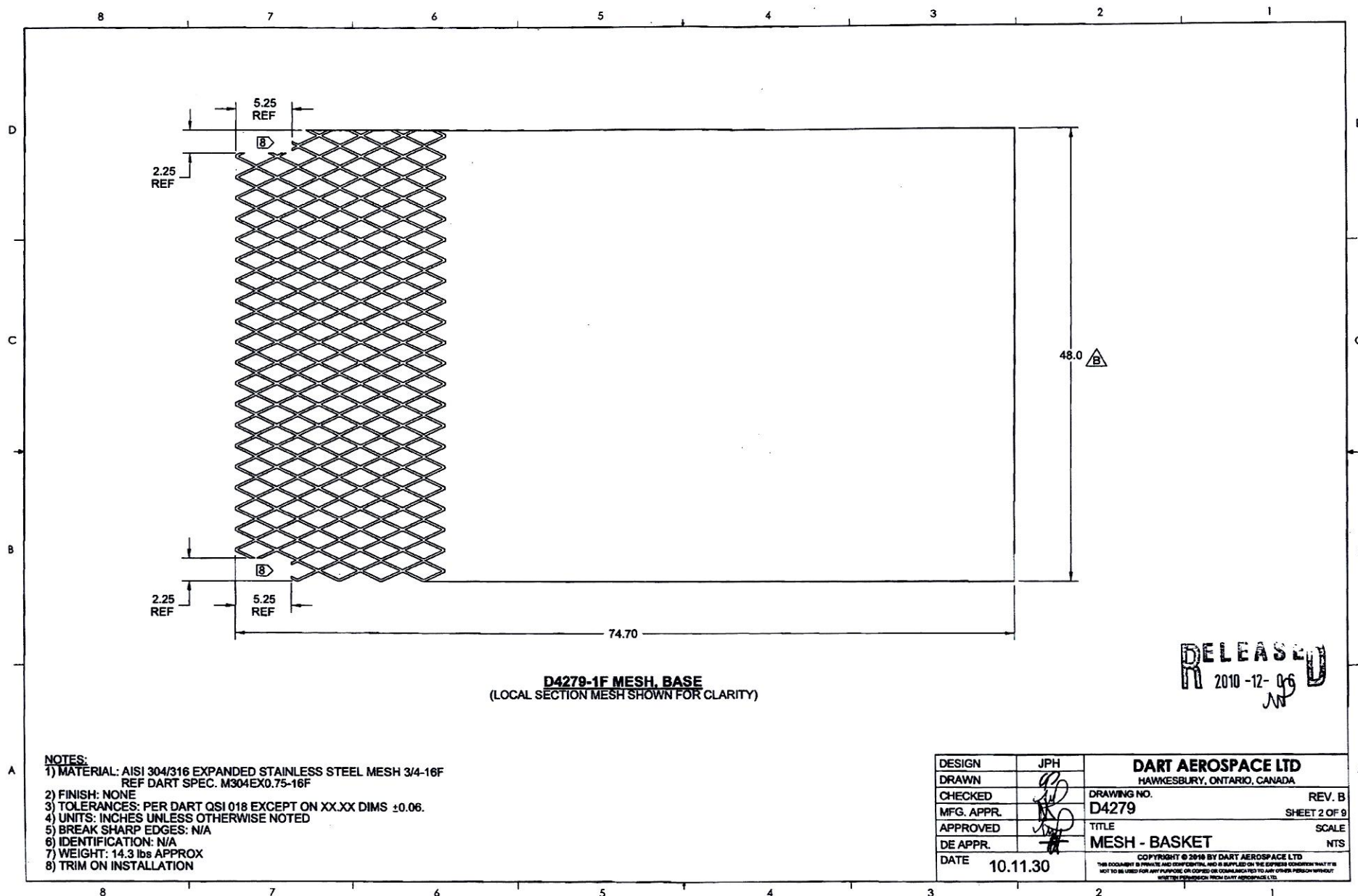
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 EXCEPT FOR XX.XX DIMS: ± 0.06
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 24.77 lbs
 - 8) WELD PER DART QSI 004

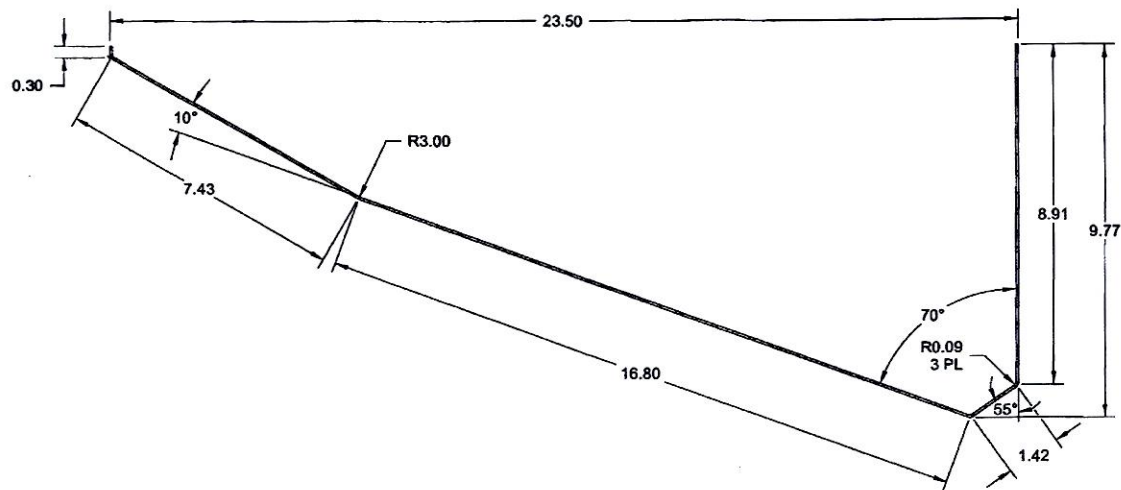
UNDER REVIEW
URF16-640 CP 16.09.07

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2012-07-12
ap

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4273	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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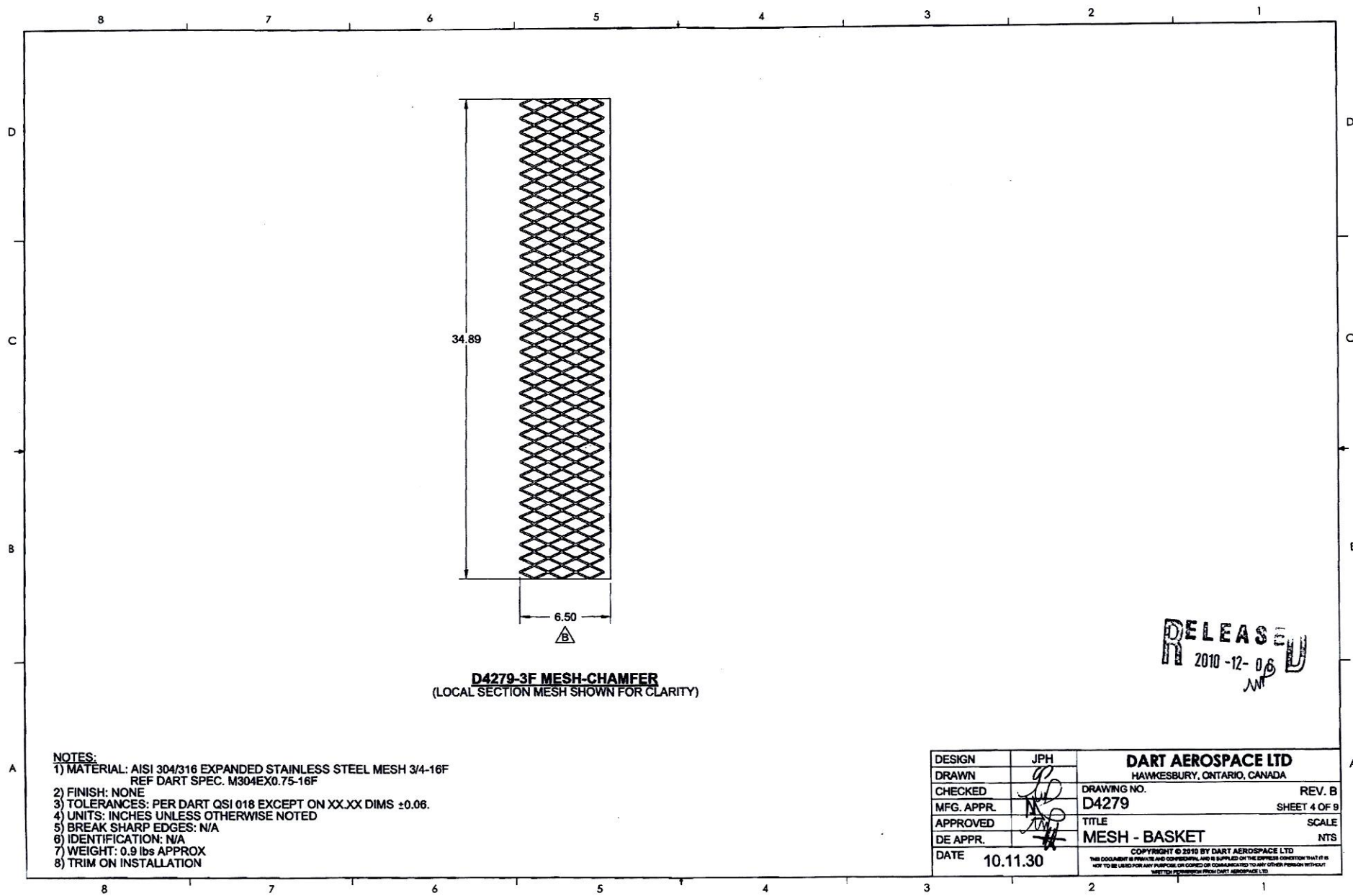
D4279-3 MESH-CHAMFER

RELEASED
2010-12-08

NOTES:

- 1) MATERIAL: MAKE FROM D4279-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-3F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4279	SHEET 3 OF 9
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MESH - BASKET	NTS
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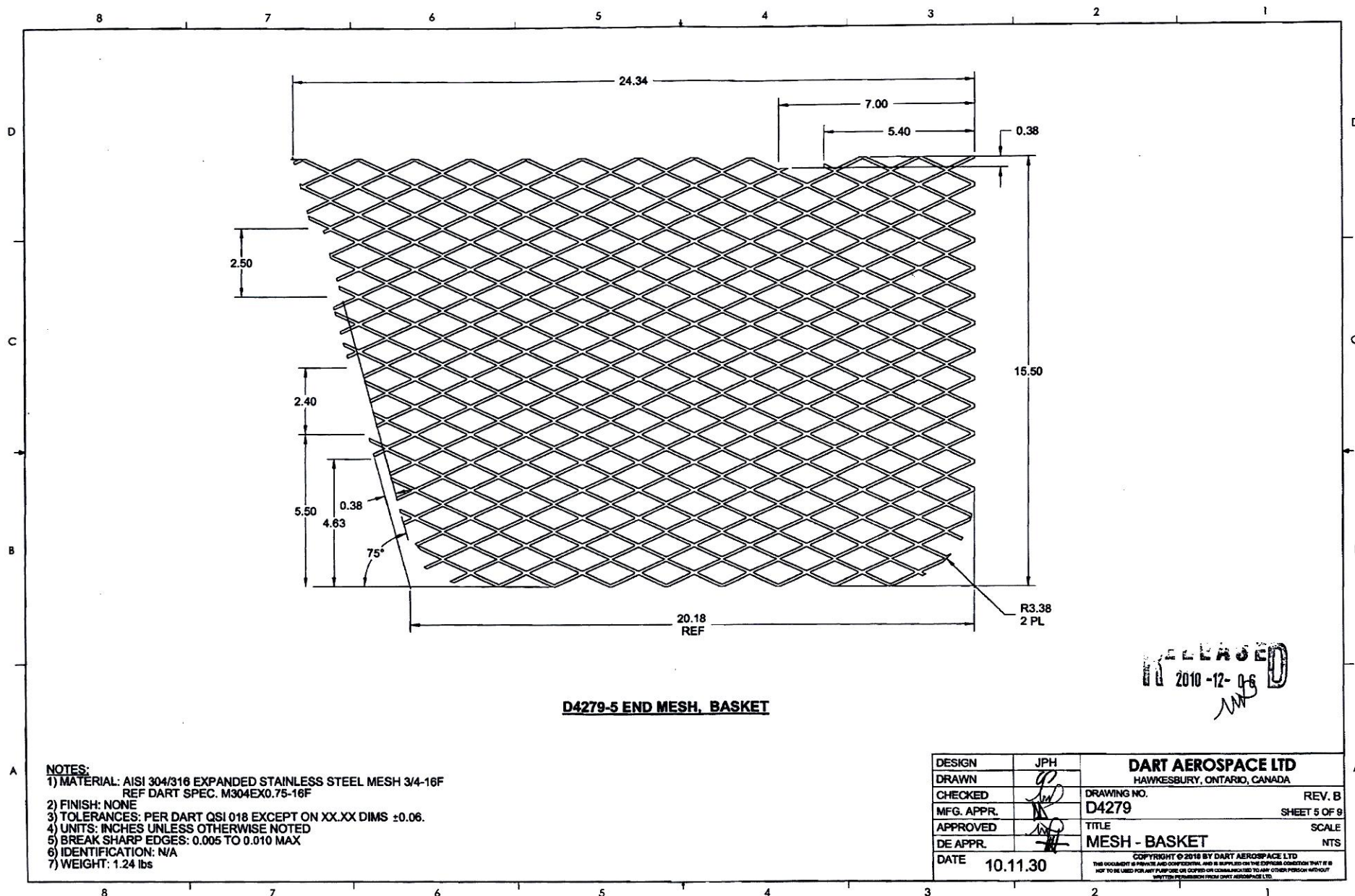
D4279-3F MESH-CHAMFER
(LOCAL SECTION MESH SHOWN FOR CLARITY)

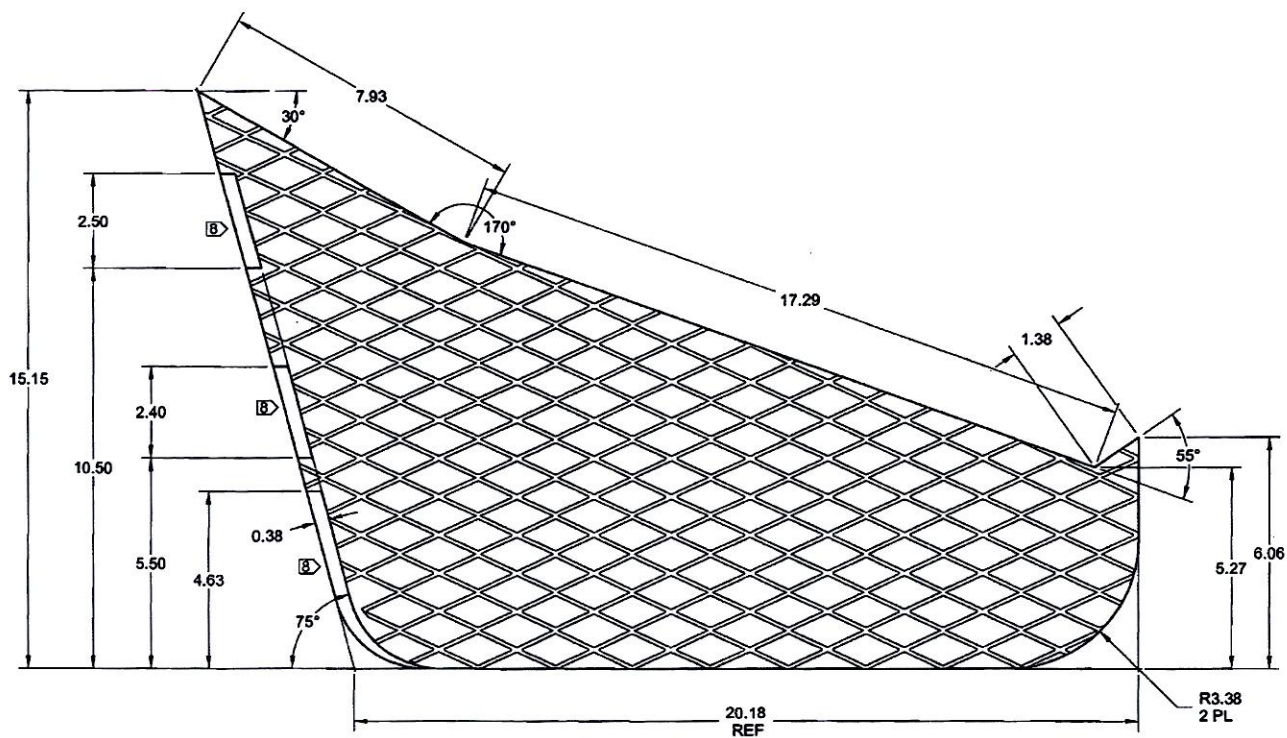
RELEASED
2010-12-06
MM

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.9 lbs APPROX
- 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4279	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
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D4279-7 END MESH. BASKET

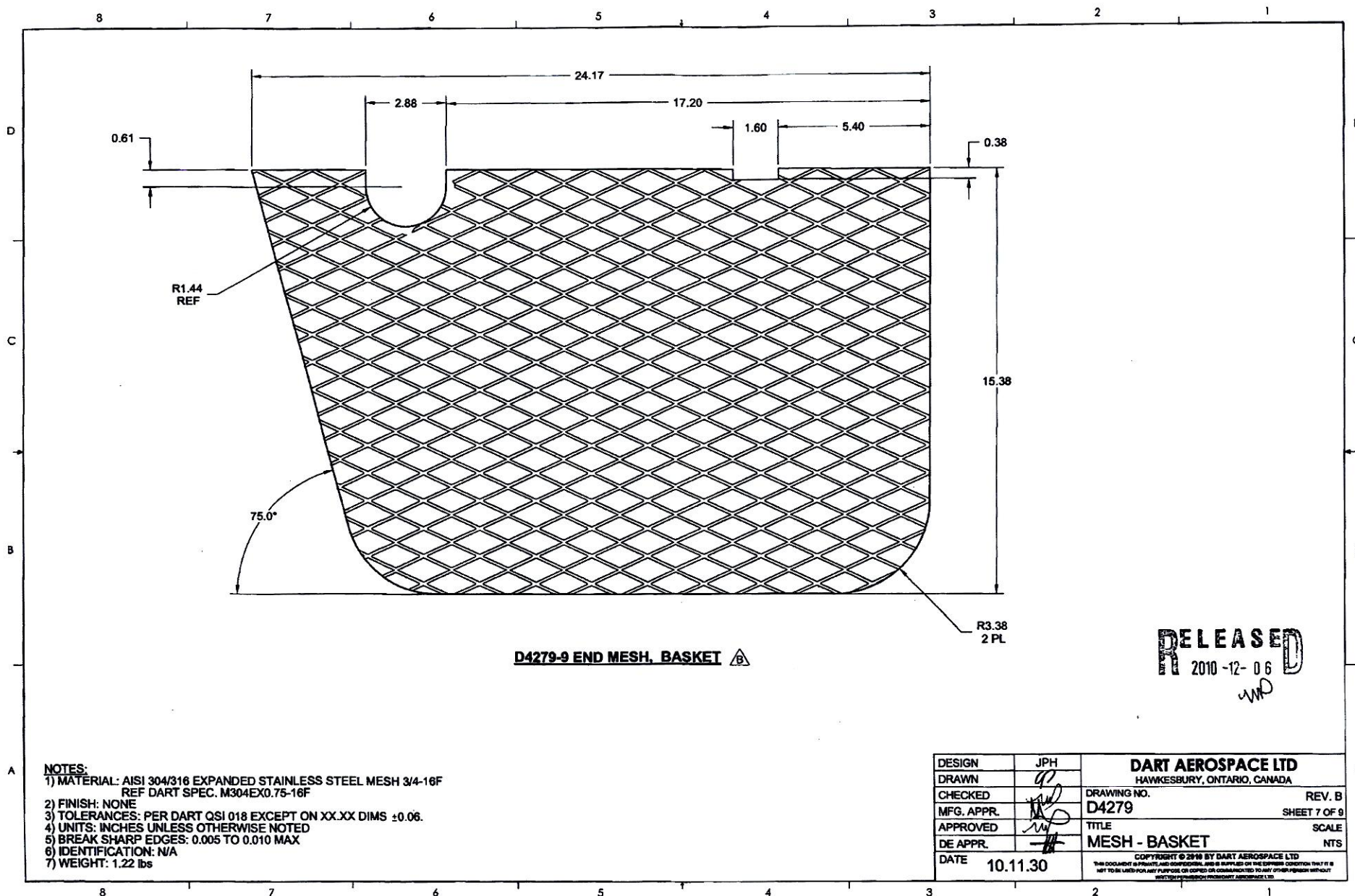
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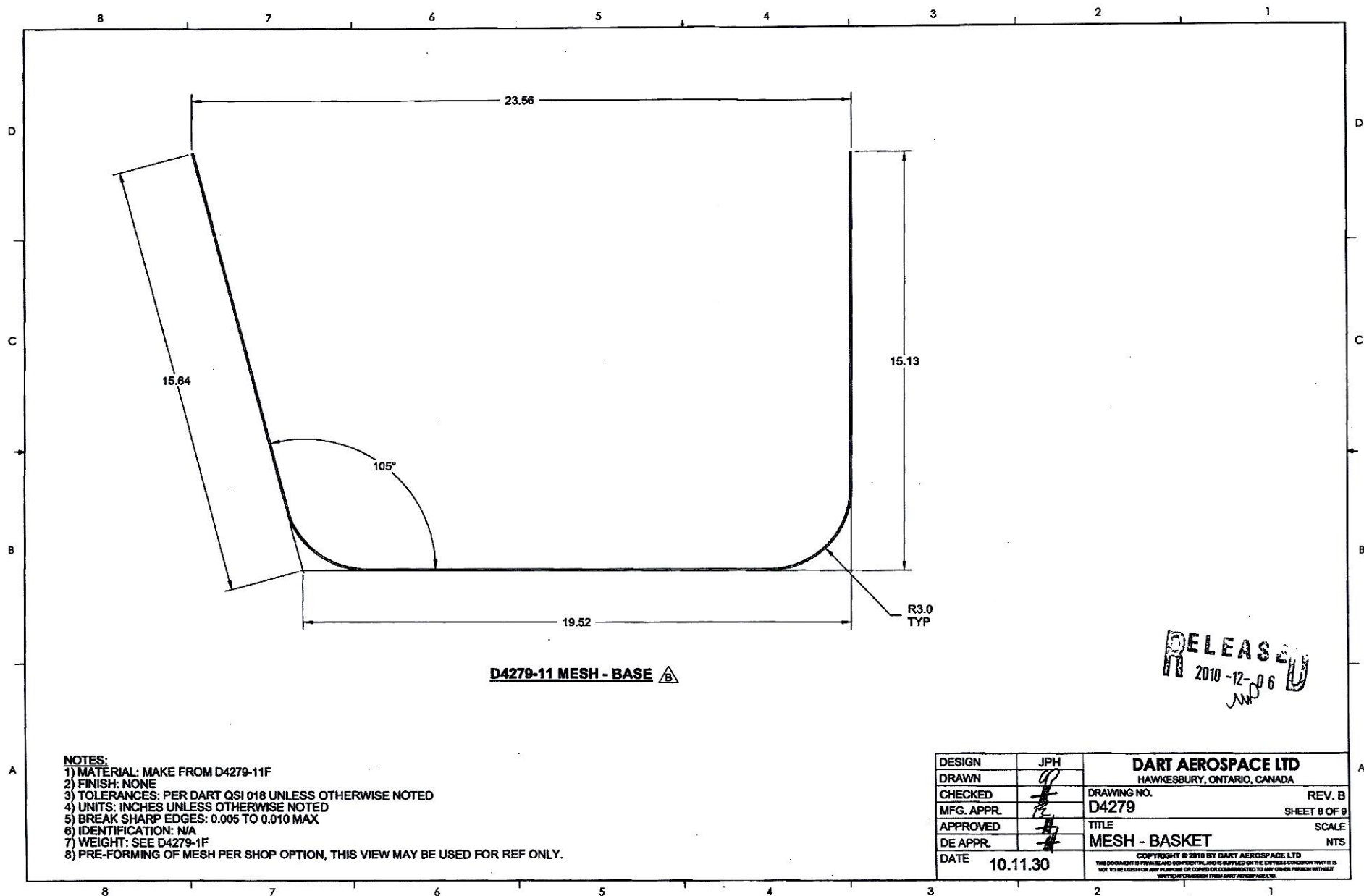
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.71 lbs
- 8) TRIM ON INSTALLATION TO CLEAR HOLES (IF PRESENT)



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4279	SHEET 6 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	MESH - BASKET	NTS
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